

SLP 18/11/11
76577

Work Order ID 76577

November-17-11 1:48:45 PM

Page 1

Item ID: D3234-1

Accept

Revision ID: U/R

Item Name: Doubler

Start Date: 17/11/2011 Start Qty: 5.00

5

Required Date: 17/11/2011 Req'd Qty: 5.00

5

~~PRELIMINARY ISSUE~~
N900040100 Setup Start *NS1*
Stop *NS2*

Reference:

Approvals: Process Plan: M.L.J

Date: 11/11/11

Tooling:

Date:

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3234	PC3								

100

100

Waterjet

FLOW WATER JET

0.00

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76577

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Page 2

Item ID: D3234-1

Accept

N900040100

Setup Start

NS1

Revision ID: U/R

Item Name: Doubler

Stop

NS2

Start Date: 17/11/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 17/11/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Hand Finishing

Memo

0.00

5X ØM 11/11/17

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

5 BK 11-11-17

150

Identify as per dwg & Stock Location:

0.00

150

Packaging

Packaging

Memo

0.00

Ph →

POSITIVE RECALL

EFFECTIVE 11-11-17 AUTH ✓

RELEASED DATE

MF
11-11-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3234-1 PAR #: Fault Category: Eng NCR: Yes No DQA: *John* Date: 11/11/29
 Resolution: *Scrap* Disposition: *Scrap* QA: N/C Closed: *OK* Date: 11/11/30

NCR: 11-1019		WORK ORDER NON-CONFORMANCE (NCR) <i>18.33 x 5 = 91.5</i>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/11/21	#10	Design char. RC: CONFIGURATION CONTROL	S 11/11/21	Scrap all parts	S 11/11/21	S 11/11/21	S 11/11/21	S 11/11/21
		052042					052042	

NOTE: Date & initial all entries

Work Order ID 76577

76577

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Page 3

Item ID: D3234-1

Accept

N900040100

Setup Start

NS1

Revision ID: U/R

Stop

NS2

Item Name: Doubler

Start Date: 17/11/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 17/11/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-17-11 3:08:53 PM

Page 1

Work Order ID: 76577

76577
D3234-1

Parent Item: D3234-1

Parent Item Name: Doubler

Start Date: 17/11/2011

Required Date: 17/11/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 08-08-14 JLM Verified By:EC
IPP Rev:B 08-12-18 as per ECN08-582 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased		No		100	sf	77.1000	0.579	3.047368		17/11/11	

M2024T3S.050

2024-T3 .050 sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	77.1	
117684	77.1	

117684

(5)

DART AEROSPACE LTD

Work Order: 176577

Description: Double

Part Number: D3D 4-1

inspection Dwg: D3034-1. Rev: DC 3

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
$\phi 1.098$	$+.004 - .001$	1.06	+		V	IB02
1.523	$+.010$	1.522	2		V	
2.641	$-.010$	2.642	2		V	
3.758	$-.010$	3.761	1		V	
5.993	$-.010$	5.991	2		V	
7.111	$-.010$	7.113	2		V	
8.228	$-.010$	8.232	1		P	PROJ302
10.463	$-.010$	10.466	2		P	
10.974	$-.030$	10.787	2		P	
2.354	$-.030$	2.245	2		V	
13.333	$-.010$	13.333	1		T	IB01
15.366	$-.010$	15.366	0		T	
15.665	$-.010$	15.166	0		T	
1.334	$-.020$	1.33	2		V	
4.505	$-.010$	4.505	2		V	
.285	$-.010$.286	1		V	
1.295	$-.010$	1.291	2		V	
2.305	$-.010$	2.301	2		V	
2.700	$-.010$	2.700	2		V	
.050	$-.010$.049	2		V	

Measured by: 

Audited by: 

Prototype Approval:

Date: 11-11-17

Date: 11/11/17

Date:

Rev	Date	Change
A		New Issue

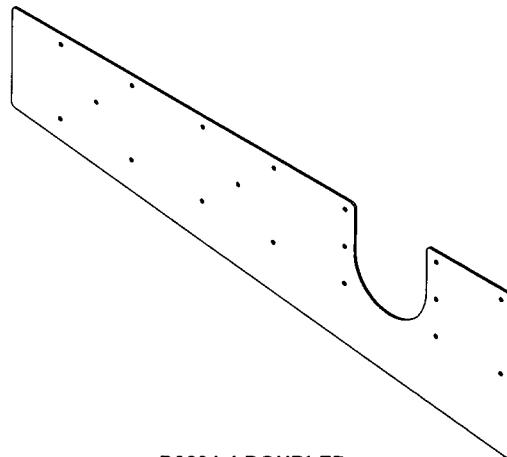
to PCI Day only

Revised by Approved
KJ/JLM

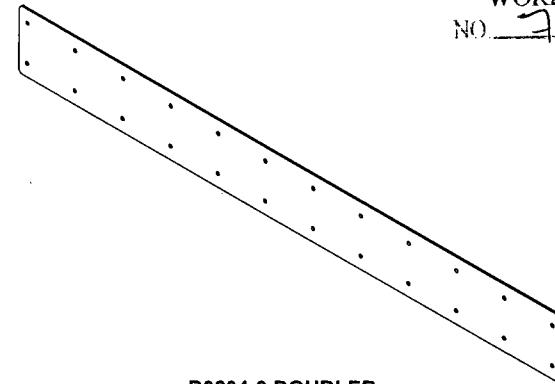
8 7 6 5 4 3 2 1

D

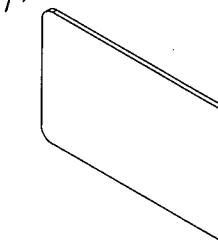
D



D3234-1 DOUBLER



D3234-3 DOUBLER



D3234-5 SPACER

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 76577 M.L.J

11/11/17

C

C

B

B

NOTES:

1) MATERIAL: -1 & -3: 2024-T3 ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/4 OR AMS 4037

REF DART SPEC M2024T3S.050

-5: 5052-H32 ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF DART SPEC M5052H32S.050

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1

7) WEIGHT: -1: 0.26 lbs

-3: 0.15 lbs

-5: 0.01 lbs

PRELIMINARY ISSUE

PC 11.09.29

PC3	RE-DESIGNED D3234-1 TO FIT D3025-1 REV. B. ZONE C3-2, 4.505 WAS 5.347, ZONE D8-2, 2.700 WAS 2.841. REASON: REF PAR 11-18.	<i>PC</i>	11.09.29
B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. PARTS FULLY DIMENSIONED. NO PHYSICAL CHANGES MADE TO PARTS. REASON: REF PAR 08-029.	AJS	08.11.24
A	NEW ISSUE	CP	03.11.19
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PC</i>	DART AEROSPACE LTD	
DRAWN	<i>PC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PC</i>	DRAWING NO.	REV. PC3
MFG. APPR.	<i>PC</i>	D3234	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	11.09.29	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

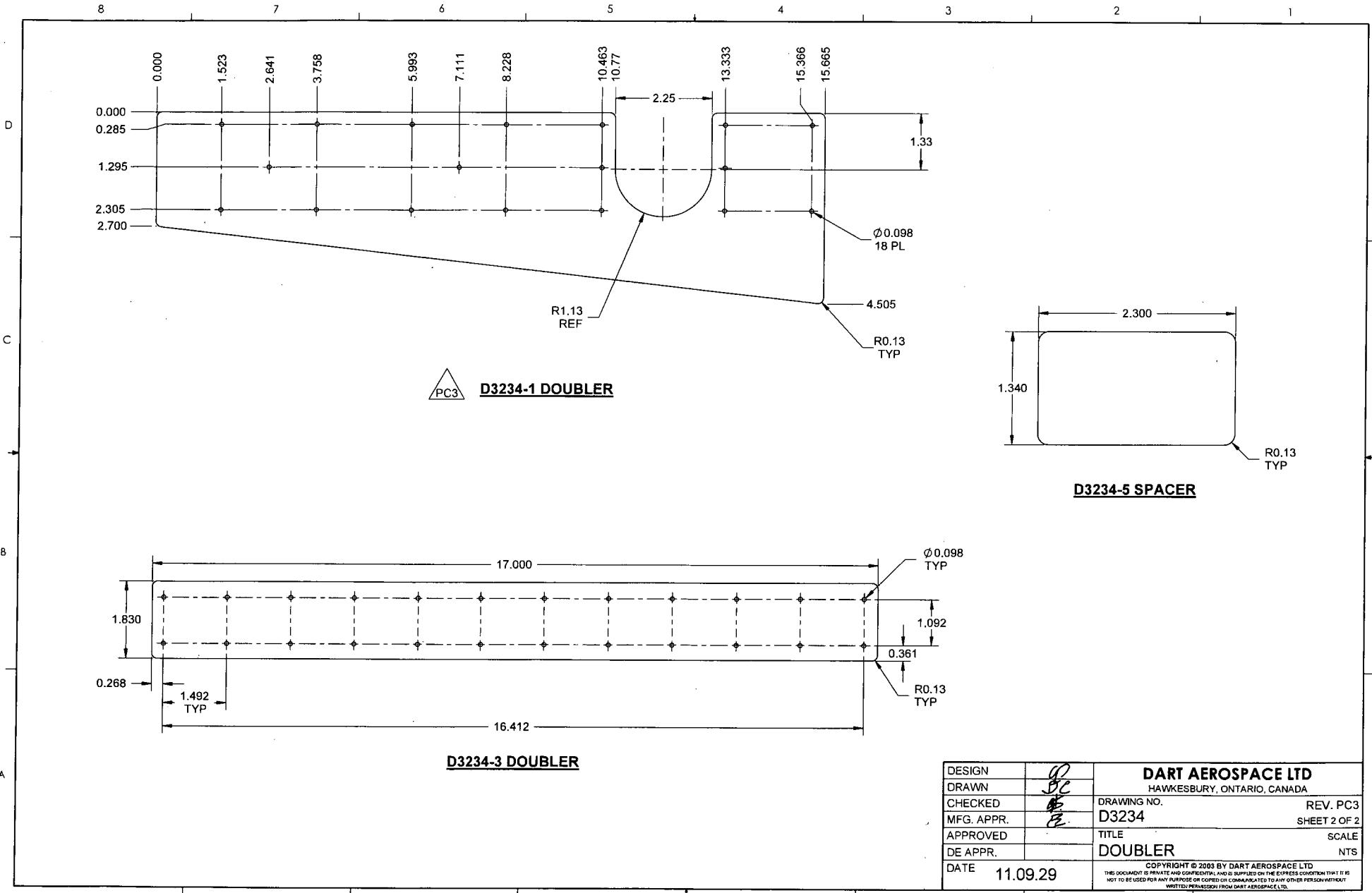
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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